



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DSK078

Job Sheet 194241



Part No: DSK078

Job Qty: 10 pcs

Part Name: D2893-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/29/19

Job Tracking No:

Due Date: 5/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	5/24/19	5/24/19	0.50	8.77	Doosan - 1		DAS 5 5-89
110	QC 2	10 pcs	5/24/19	5/24/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

19/05/19
Finish at 7h30AM
plex on
maintenance



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S180404



Part: DSK078

Job No: 194241

Serial No/Batch: S180404

Revision:

Inspector:

Exp Date:

Instructions:

Date: 05/12/19

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120 QC 8	10 pcs	5/24/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	VH 8 19/5/15
130 Packaging 3-1 - Stock - B4B	10 pcs	5/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	VH 8 19/5/15
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

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				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	5/24/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Doosan (Doosan Lathe) Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492) Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-4 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) LOCATION: MAT060 140 - QC21 (QC21- Final Inspection - Work Order Release)					DAS 21 9-88 MAY 15 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6104-005	Round Billet, 17-4	10 pcs (1 ea)	100-Doosan - 1	S127/26 x10	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6104-005	10	28	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 194241
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	DAS 5 9-89	2.710	2.709	2.708	2.710	2.709
B	4.946	4.966		4.953	4.955	4.955	4.955	4.955
C	3.064	3.084		3.074	3.0745	3.0745	3.0745	3.0745
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.102	.102	.1015	.102	.102
F	2.934	2.954		2.9445	2.944	2.944	2.944	2.944
G	2.166	2.186		2.175	2.175	2.176	2.175	2.175
H	3.890	3.910		3.9	3.9	3.9	3.9	3.9
I	0.914	0.934		.925	.926	.928	.928	.928
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.1165	.117	.1185	.1165	.117
L								
M								
N								
O								
P								

Measured by: JWC **Date:** 19/05/11

Audited by: **Date:**

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 194241
Description: Turning Detail for D2893-1		Part Number: DSK078
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FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**

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K	0.109	0.129						
L								
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N								
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P								

Measured by:	Date:
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Audited by:	Date:
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Prototype Approval:	Date:
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A	08.04.22	New Issue	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					